

**BELL SYSTEM PRACTICES**  
**Outside Plant Construction**  
**and Maintenance**

**SECTION G73.125.1**  
**Issue 1, September, 1952**  
**AT&T Co Standard**

## **PRESSURE TESTING**

### **SOLDERING MOLDS**

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#### **1. GENERAL**

1.01 This section covers the method of using the B, C and D Soldering Molds. It replaces the related information in Section G73.206, Issue 1 which is cancelled, and Part 9 of Section G85.140.1, Issue 1.

1.02 These molds are used for soldering lead pipe connections and valves to lead covered cable and lead sleeves.

#### **2. TOOL LIST**

2.01 Following is a list of the cable molds. Each of the molds has a spring and chain assembly for securing it to the cable.

**Mold, Soldering, B** For soldering lead pipe connections on top surface of cables and sleeves.

**Mold, Soldering, C** For soldering lead pipe connections on the sides of cables.

**Mold, Soldering, D** For soldering valves on the sides of cables.

#### **3. METHOD OF USE**

3.01 Before placing the mold, clean the sheath and prepare the opening in the usual manner. Coat the surface of the sheath or sleeve with stearine.

3.02 On cable having normal dielectric strength, tap the mold lightly to seat the chisel edges slightly in the sheath or sleeve.

3.03 On high dielectric strength cable, where the raised sheath method of preparing the sheath is used, the mold must not be tapped to secure tight seating, since this may

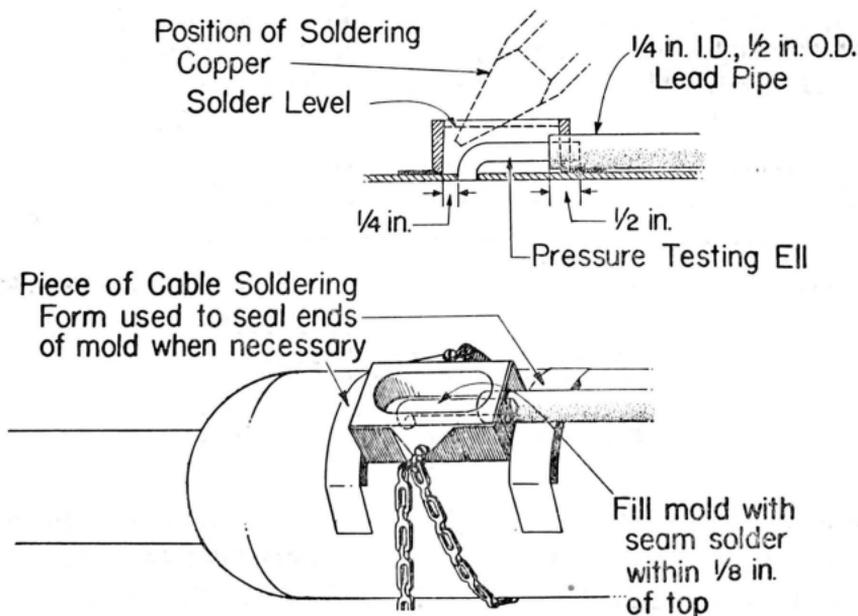
depress the raised sheath and reduce the dielectric strength between the conductors and the sheath. Plastic Duct Seal should be used to seal the joint between the chisel edges of the mold and the sheath in this case. Pieces of a Cable Soldering Form or Plastic Duct Seal may be used to seal the ends of either mold when necessary to avoid the loss of molten solder from the mold.

3.04 When a soldering copper is used in filling the mold it should be well tinned, kept in continuous motion and the metal kept in a molten state to permit tinning of the various parts. Do not allow the hot soldering copper to come in contact with the sheath or sleeve. If a Prestolite Torch is used when filling the mold on aerial or buried cable, direct the heat on the mold rather than on the copper ell or lead pipe. This is done to prevent melting the sheath or pipe.

3.05 Remove the soldering copper or torch from the mold as soon as the tinning operation is satisfactorily completed. Allow the solder to set before removing the mold.

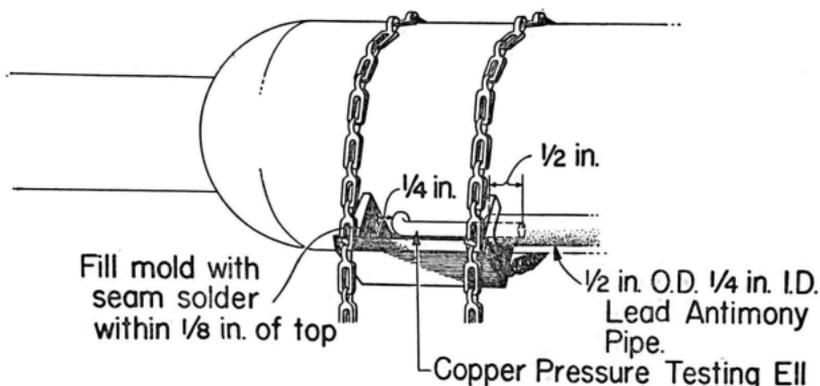
3.06 To remove the mold, disconnect the binding chains and gently tap the mold until it releases.

3.07 **B Soldering Mold:** The following sketch illustrates the use of the B Soldering Mold in attaching a lead pipe to a sleeve. This mold is designed for use on cables and sleeves 1-1/2 inches and larger in diameter.

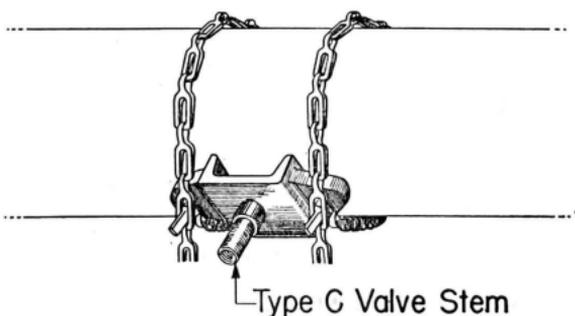


3.08 When using the B Soldering Mold on aerial cable, it is advisable to offset it slightly from the vertical to minimize possible interference with the strand.

3.09 **C Soldering Mold:** The following sketch illustrates the use of the C Soldering Mold in making a lead pipe connection to the side of a cable or sleeve. This mold is designed for use on cables of one-inch diameter or larger.



3.10 **D Soldering Mold:** The following illustrates the use of the D Soldering Mold in soldering Type C Pressure Testing Valves directly to the side of cables or sleeves. This mold is designed for use on cables of 1-1/2-inch diameter or larger.



3.11 Where a valve is to be installed on the side of a cable, the sheath should be prepared by the muslin spacing method described in the section on sheath preparation for valves.